

Work Order ID 133199

Tuesday, May 26, 2015 12:51:09 PM

133199

Page 1

Item ID: D3805-047 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Run-on Landing Wearplate Aft
 Start Date: 5/26/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/26/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAY 27 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	C								

100

0.00

100

Large Fab

Large Fab

Memo

0.00

1- On D3806-7, fill cut outs with hardcoat welding rod as per dwg D3805

2059 B Hardcoat Welding Rod

BATCH#: M130745

2-weld D3806-7 to D3805-7 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M128077

3-Transfer drill holes in bar

CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT

x4 MAL 15-07-08

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

④ 15-07-08 DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 2

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Item ID: D3805-047

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Run-on Landing Wearplate Aft

Start Date: 5/26/15

Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/26/15

Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop *NR2*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(4) 15-07-09

DAS
9
9-89

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 dwg
D3805.

TEXTURED COATING B#: 132390

4

DAS
41
9-89
15-7-10

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

(4)

DAS
38
9-89

JUL 13 2015

DQA: _____ Date: _____



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Revision ID: Stop *NS2*

Item Name: Run-on Landing Wearplate Aft

Start Date: 5/26/15 Start Qty: 2.00 *2* Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 2.00 *2* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

Handwritten notes: MC5 JUL 13 2015

Handwritten notes: MC5 JUL 13 2015

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, May 26, 2015 12:51:08 PM

Page 1

Work Order ID: 133199

133199

Parent Item: D3805-047

D3805-047

Parent Item Name: Run-on Landing Wearplate Aft

Start Date: 5/26/15

Required Date: 5/26/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevB: add transfer drill wearplate to bar DD 09.11.05 verf:EC IPP Rev:C
11.10.04 rev.b as per dwg DD verified by:EC IPP REV:D 14.04.22
DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3805-7 Manufactured No Each 23.0000

2

D3805-7

Plate

Location	Loc Qty	Loc Code
WA001	23	
120181	3	
127089	8	
127106	12	

x 4

44 MAL 15-07-08

D3806-7 Manufactured No Each 4.0000

2

D3806-7

Bar

Location	Loc Qty	Loc Code
WA001	4	
103292	4	

44 MAL 15-07-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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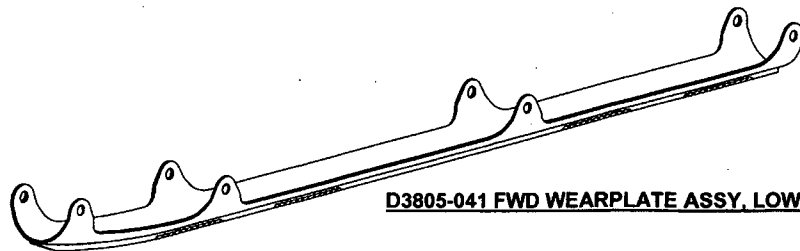
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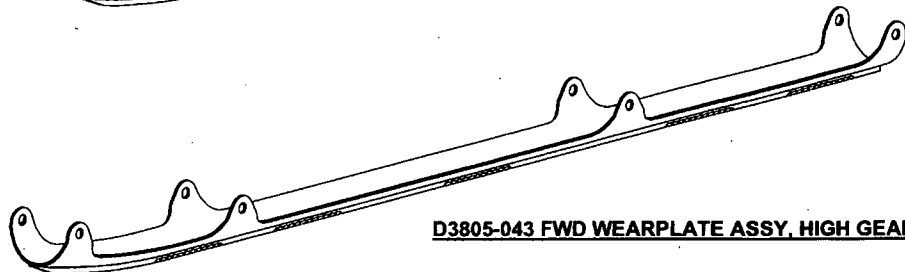
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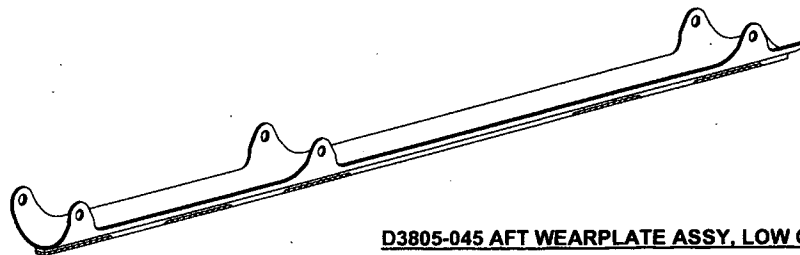
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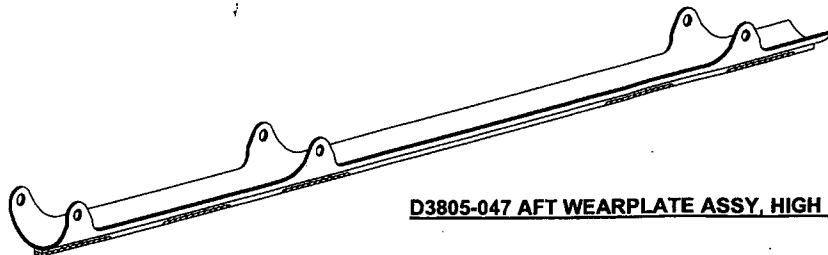
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT

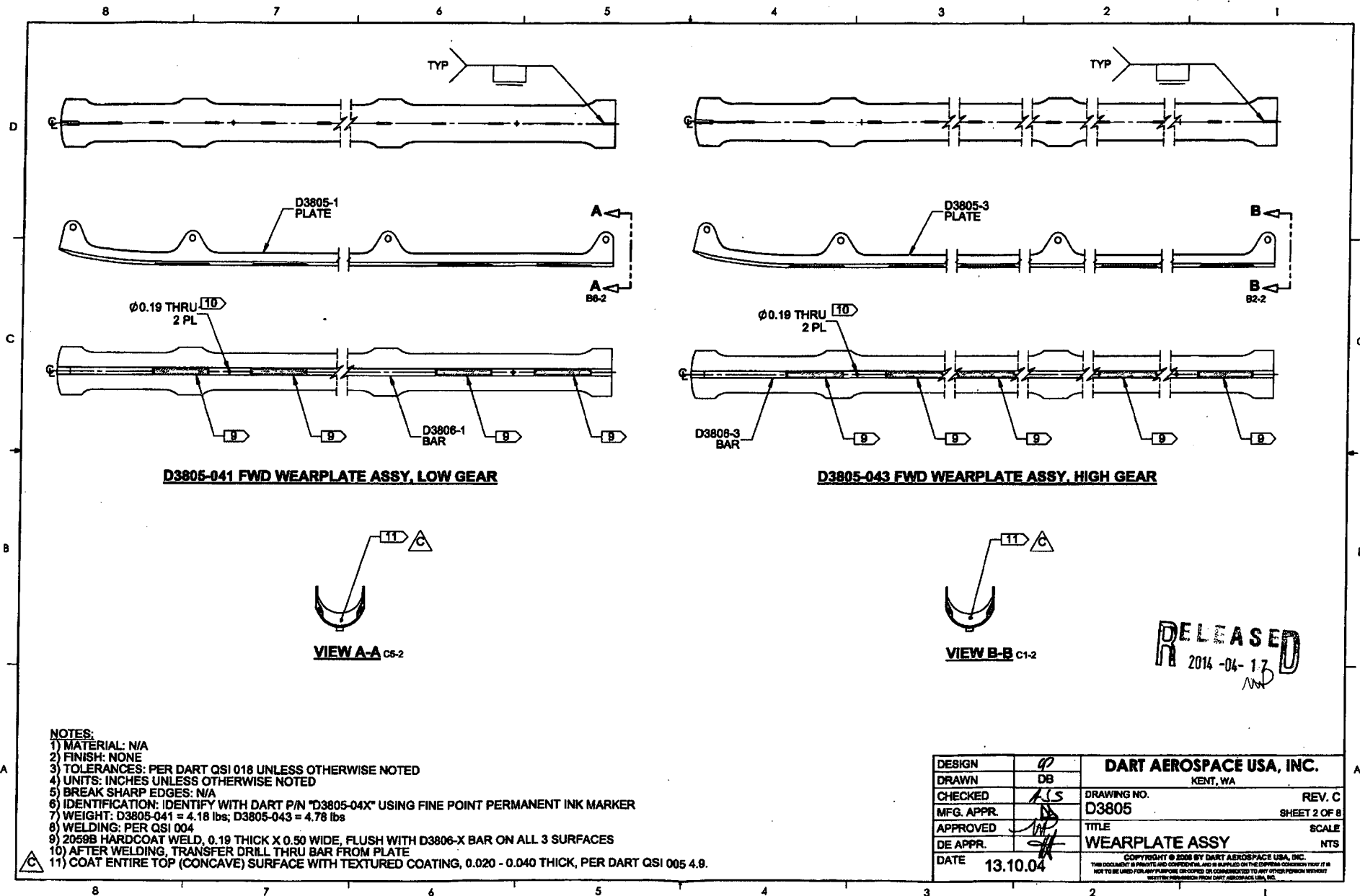
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SHOP COPY
RETURN TO
ENCLOSURE
UNCONTROLLED COPY
SUBJECT TO RECALL
WITHOUT NOTICE
WORK ORDER
NO. 133199-1109

150527

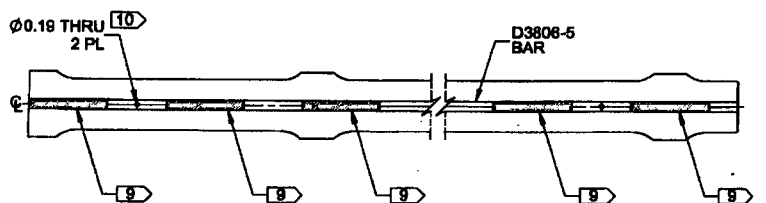
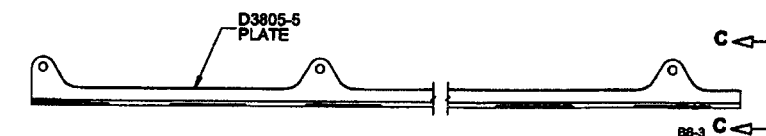
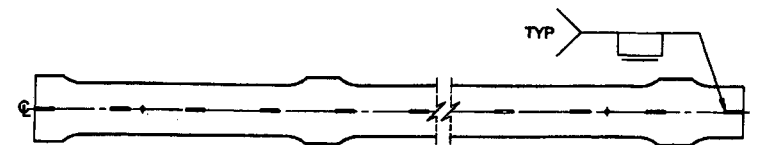
RELEASED
2014-04-17

C	REMOVE ITEMS 19, 20, 21, 22 AND 32 FROM BOM (ZN C4-1), REVISE NOTE 11, SHEETS 2&3 (ZN A8-2, B2-2, B6-2, A8-3, B2-3, B6-3)	DB	13.10.04
B	REVISED D3805-1F/-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	g	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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MFG. APPR.	MP	D3805	SHEET 2 OF 8
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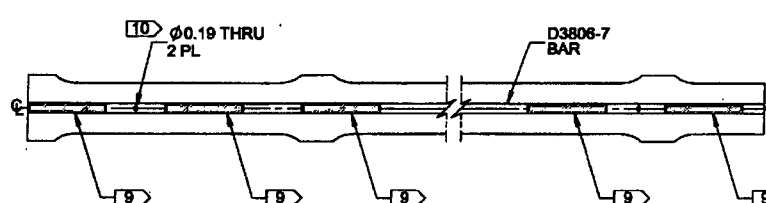
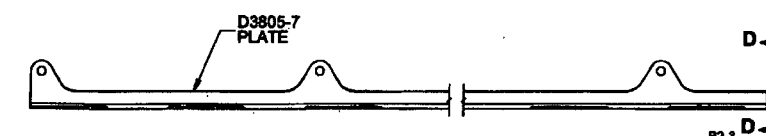
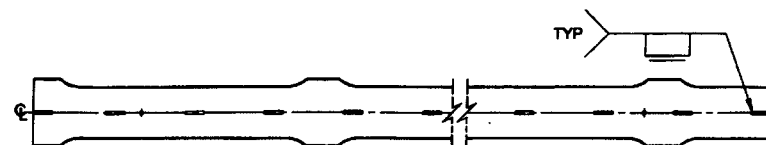
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D3805-045 AFT WEARPLATE ASSY.



VIEW C-C C5-3



D3805-047 AFT WEARPLATE ASSY.



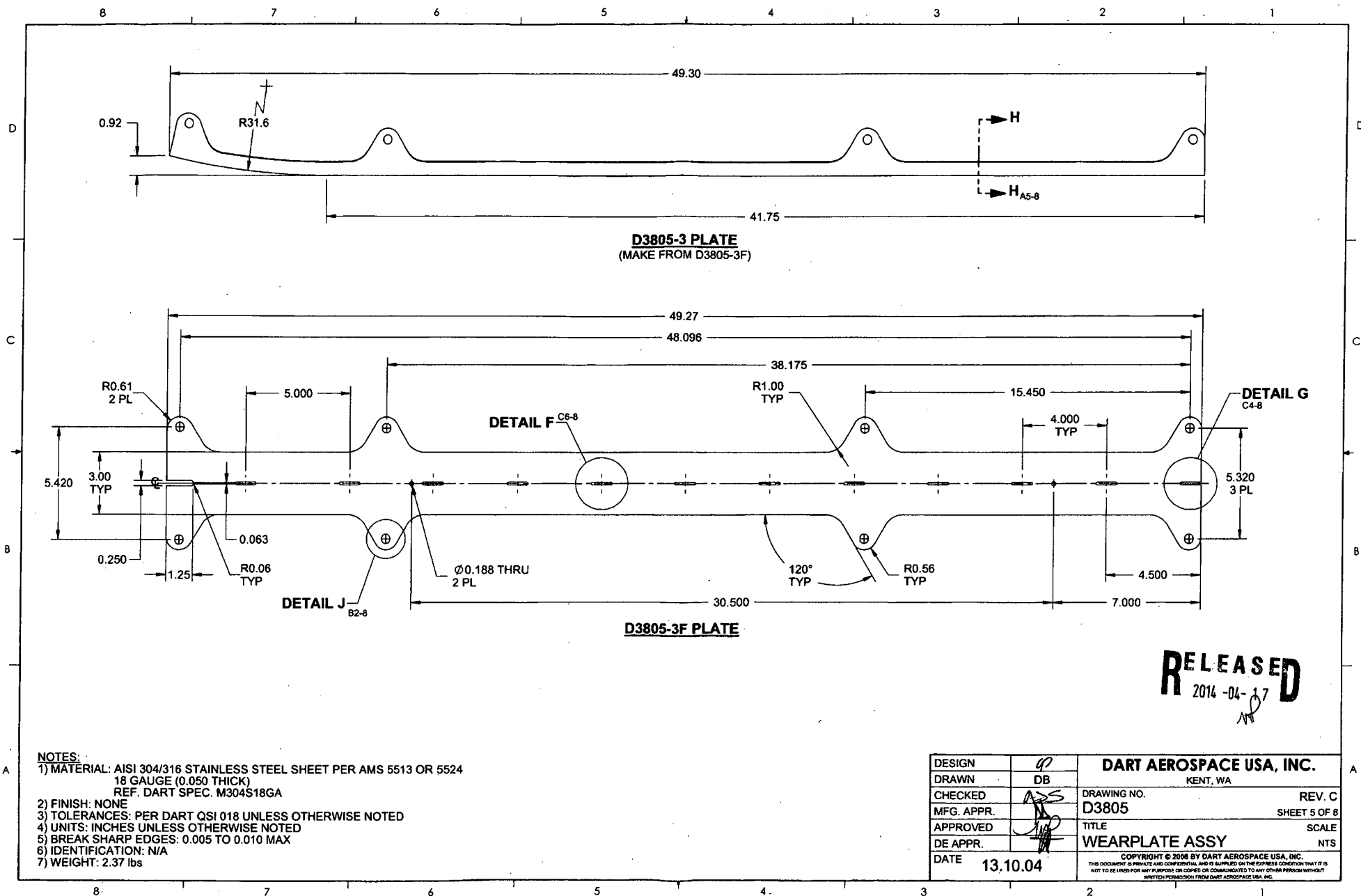
VIEW D-D C1-3

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2014-04-17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

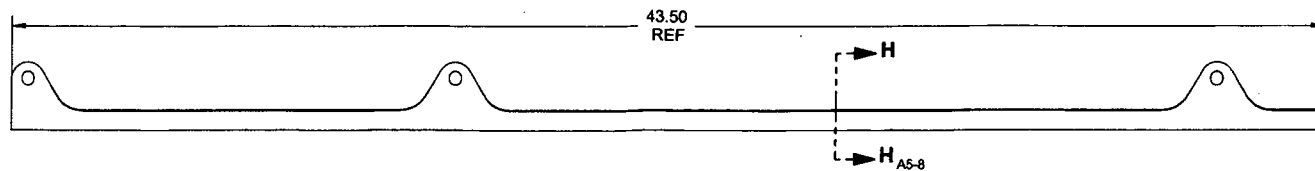
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MFG. APPR.		D3805	SHEET 3 OF 8
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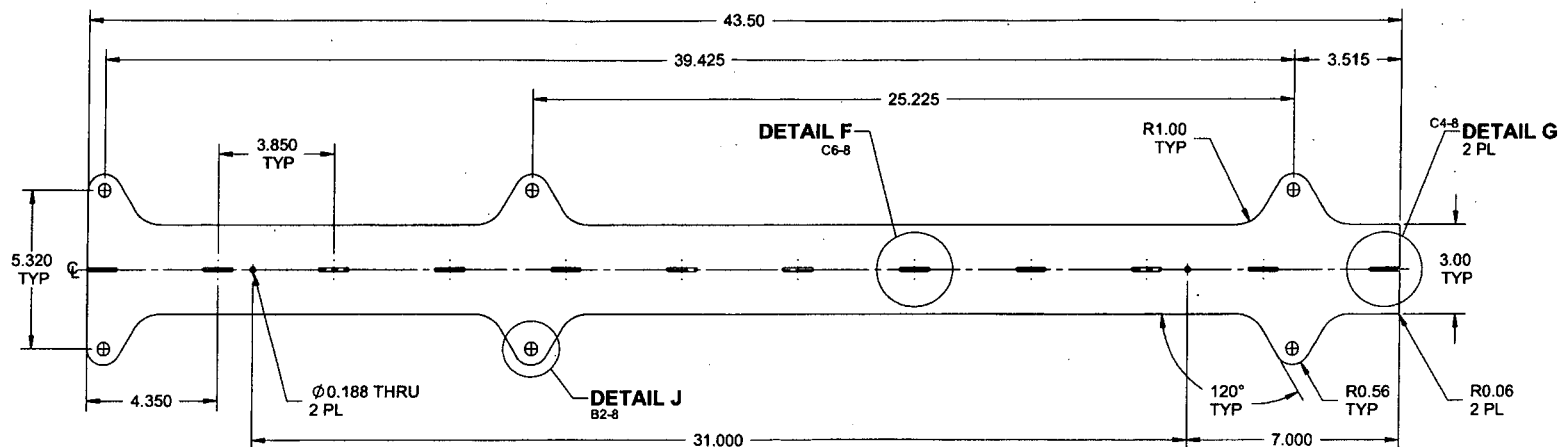
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.37 lbs

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D3805-5 PLATE
(MAKE FROM D3805-5F)



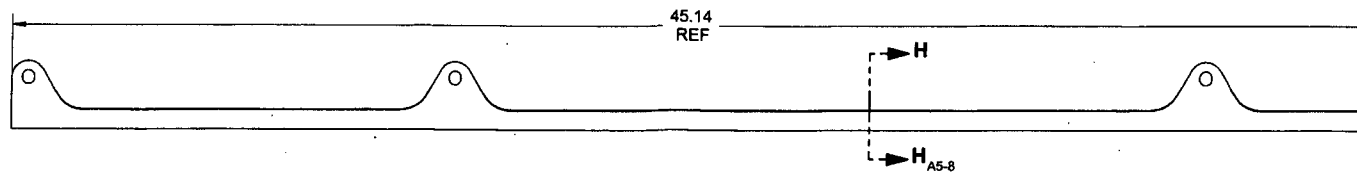
D3805-5F PLATE

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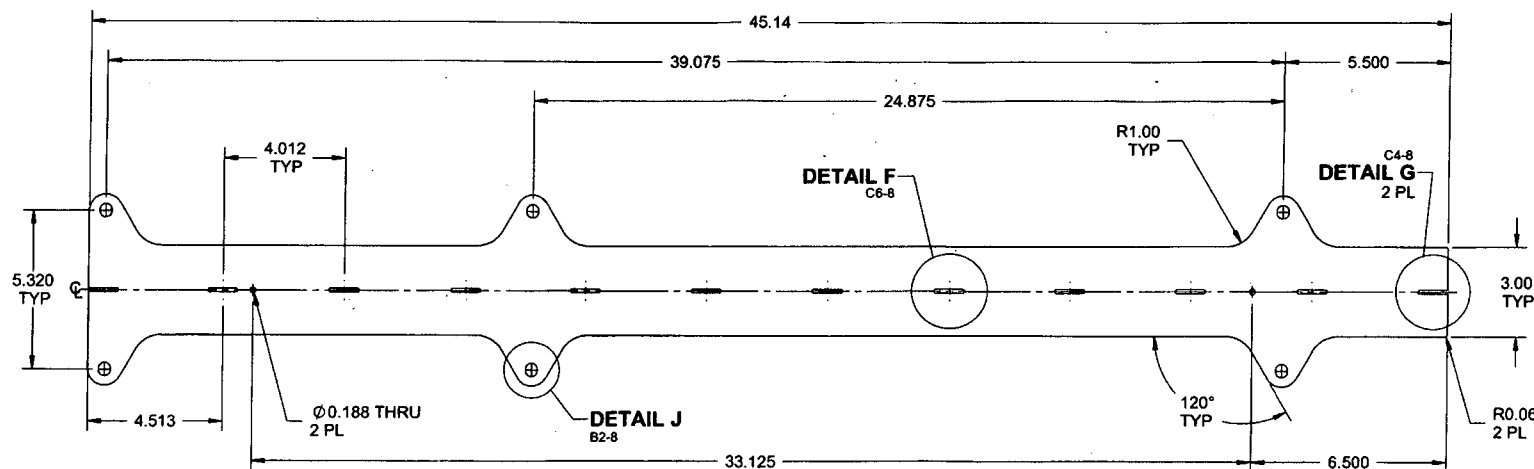
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

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D3805-7 PLATE
(MAKE FROM D3805-7F)



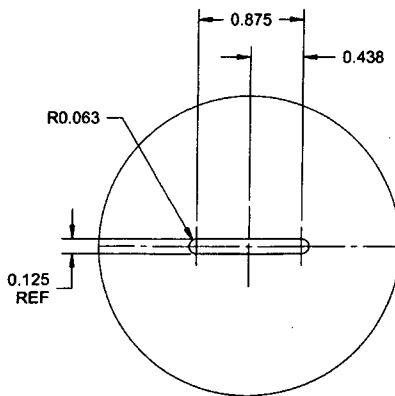
D3805-7F PLATE

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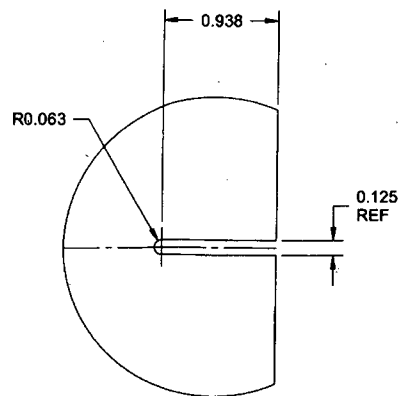
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

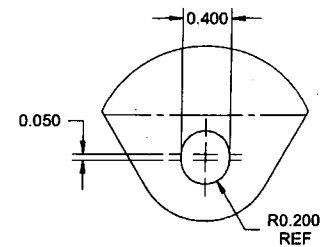
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MFG. APPR.		D3805	SHEET 7 OF 8
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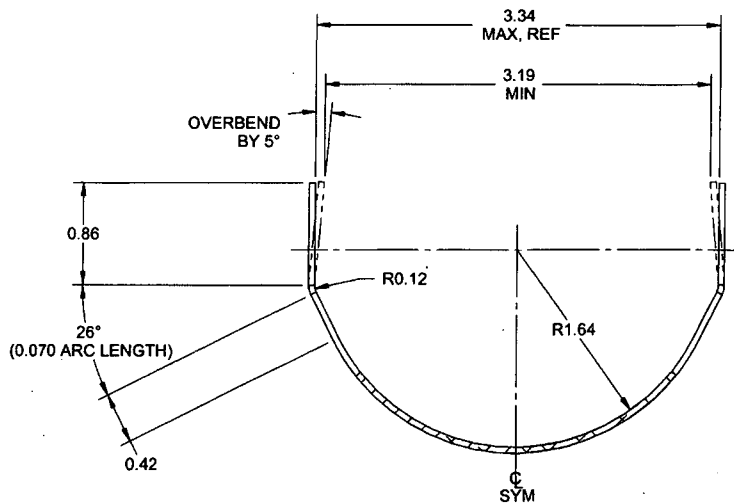
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

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